

Work Order ID 55688

January 27, 2010 1:13:28 PM



Page 1

Item ID: D3262-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Canister Assembly

Start Date: 1/27/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/02/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3262

Rev C

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: 1112860 0.00
Large Fab

Memo

0.00

Weld canister assembly as per Dwg D3262 using DT8739 to align fillings

Pl 10.02.01

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

1x BE 10/02/02

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Pressure test as per Dwg D3262 *S*

2) 8/10/02

86

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 55688

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Page 2

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

W 10/02/02

(X)

8

140

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

****Ensure to mask threads ****

START TIME: 10:30AM

OVEN TEMPERATURE: 320°C

FINISH TIME: 11:00AM

27 JH 10/02/02

(X)

8

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BK 10-02-02

(1)

8

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 55688

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Page 3

Item ID: D3262-041

Accept



Setup Start



Revision ID:

Item Name: Canister Assembly

Stop



Start Date: 1/27/10 Start Qty: 1.00



Cust Item ID:

Required Date: 2/02/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 144

0.00



Packaging

Memo

0.00

Packaging

10-2-3

9/12

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/04
MK 10-2-4

Picklist Print

January 27, 2010 1:13:27 PM

Page 1

Work Order ID: 55688

Parent Item: D3262-041

Parent Item Name: Canister Assembly

Comments: IPP C 05.03.10 Removed P/O for liquid penetrant inspection KJ/JLM

Start Date: 1/27/10

Required Date: 2/02/10

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|

| | | | | | | | | | | | | |
|---------|--|--------------|----|--|--|-----|------|--------|--------|--|--|--|
| D3262-1 | | Manufactured | No | | | 100 | Each | 8.0000 | 1.0000 | | | |
|---------|--|--------------|----|--|--|-----|------|--------|--------|--|--|--|



Tube

Pl 10/02/01

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 8

53504 2

55613 6

| | | | | | | | | | | | | |
|---------|--|--------------|----|--|--|-----|------|--------|--------|--|--|--|
| D3262-3 | | Manufactured | No | | | 100 | Each | 2.0000 | 2.0000 | | | |
|---------|--|--------------|----|--|--|-----|------|--------|--------|--|--|--|



Cap

① lpc ✓

Pl 10/02/01

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 2

53503 2

② lpc ✓

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

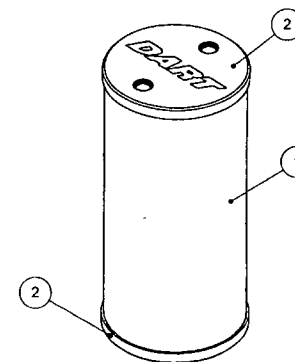
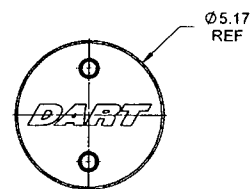
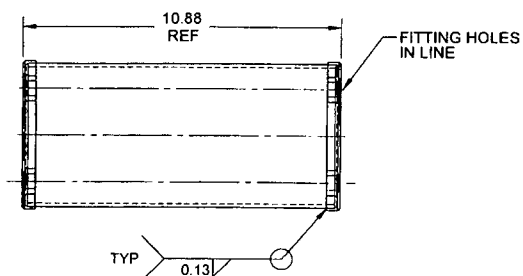
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|-------------------|
| | X | D3262-041 | CANISTER ASSEMBLY |
| 1 | 1 | D3262-1 | TUBE |
| 2 | 2 | D3262-3 | CAP |

WLO 55688



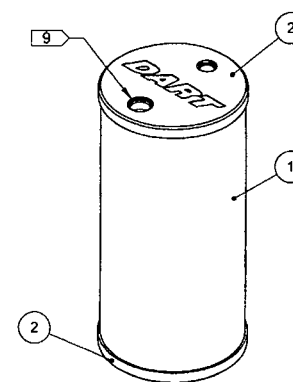
D3262-041 CANISTER ASSEMBLY

RELEASED
2010-01-14
AM

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3262-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 2.56 lbs
- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS

| D | ADD D3262-043-5 (ZN B5-2, B5-5); REVISE DIMENSIONS TO EQUAL TOOL DIMENSIONS (ZN B2-4; C2-4) PER CAR 09-004 | RF | 09.12.30 |
|------------|--|--|--------------|
| C | Ø5.165 WAS Ø5.190 | RF | 06.08.31 |
| B | ADD PRESSURE TESTING OPTION | MB | 05.02.14 |
| A | NEW ISSUE | RF | 04.05.06 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | RF | DRAWING NO. | REV. D |
| MFG. APPR. | RF | D3262 | SHEET 1 OF 5 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | FUEL PURGE CANISTER | NTS |
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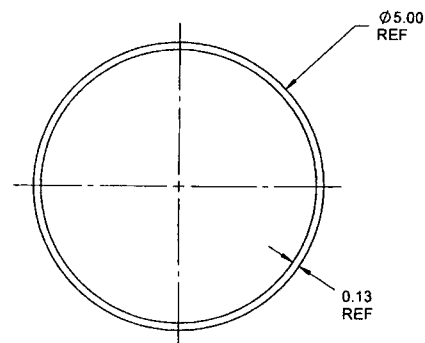
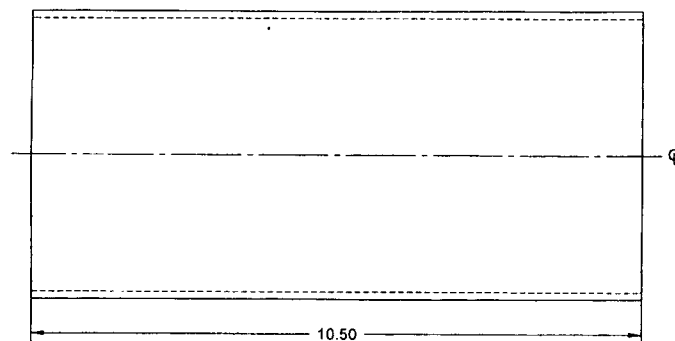
WOS 5688

mf

A

- 8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

8 7 6 5 4 3 2 1



D3262-1 TUBE

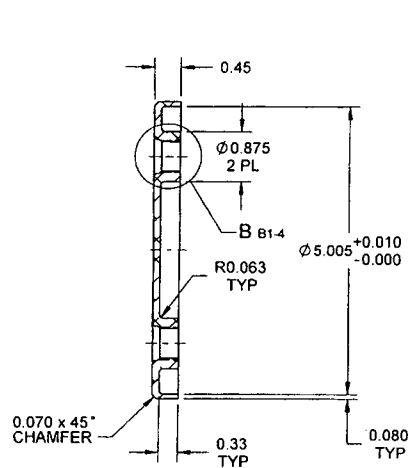
*WLO
55688*

RELEASED
2010-01-14
MP

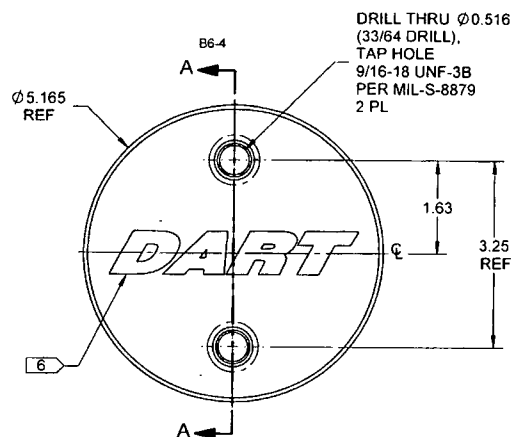
NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6T5.000W.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.96 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

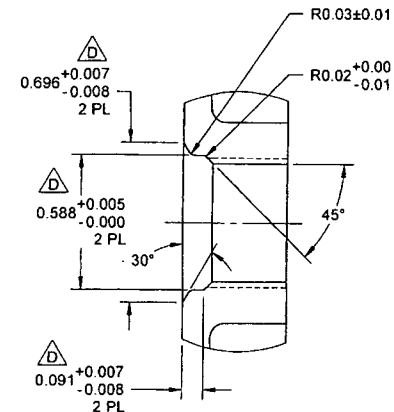
| | | | |
|------------|-----------|--|--------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>RF</i> | DRAWING NO. D3262 | REV. D |
| MFG. APPR. | <i>RF</i> | SHEET 3 OF 5 | |
| APPROVED | <i>RF</i> | TITLE | SCALE |
| DE APPR. | <i>RF</i> | FUEL PURGE CANISTER | NTS |
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SECTION A-A C5-4



D3262-3 CAP



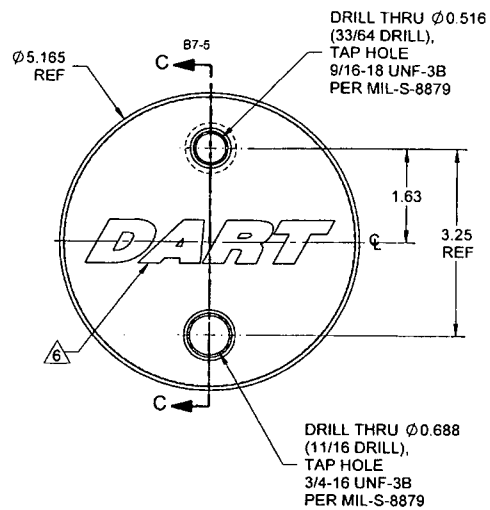
DETAIL B C7-4
SCALE 2X

NOTES:

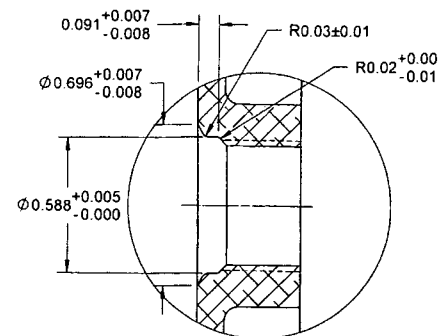
- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.30 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

| | | | |
|------------|----------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | RF | DRAWING NO. | REV. D |
| MFG. APPR. | RF | D3262 | SHEET 4 OF 5 |
| APPROVED | RF | TITLE | SCALE |
| DE APPR. | RF | FUEL PURGE CANISTER | NTS |
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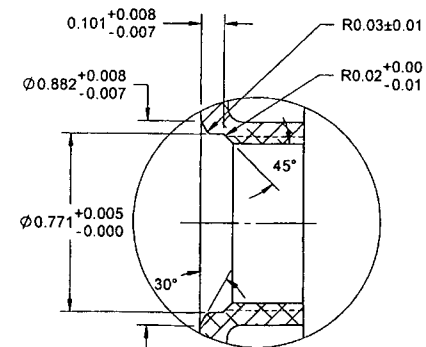
RELEASED
2010-01-14



D3262-5 CAP



DETAIL D C7-5
SCALE 2X



DETAIL E B7-5
SCALE 2X

RELEASED
2010-01-14

- 9/1 PART IS SYMMETRICAL ABOUT CENTERLINE

| | | | |
|------------|------------|---|--------------|
| DESIGN | RF | DART AEROSPACE LTD | |
| DRAWN | RF | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>RF</i> | DRAWING NO. | REV. D |
| MFG. APPR. | <i>2/1</i> | D3262 | SHEET 5 OF 5 |
| APPROVED | <i>1/0</i> | TITLE | SCALE |
| DE APPR. | <i>1/1</i> | FUEL PURGE CANISTER | NTS |
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